

Date: Monday, 9/11/2006 3:43:06 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 28476	
Estimate Number : 12487	
P.O. Number : N/A	Part Number : D35021
This Issue : 9/11/2006 S.O. No. : N/A	Drawing Number : D3502 PREL Rev. A 06.09.12
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : PREL Rev. A
Previous Run : 28089	Material : N/A
Written By : [Signature]	Due Date : 9/30/2006 Qty: 30 Um: Each
Checked & Approved By : [Signature] 06.09.12	
Comment : Est Rev:A New Issue 06-07-06 JLM Note: Estimate is currently made for manual machining .(temp only)	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X04000	6061-T6 Bar 1.0" x 4.0"
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Comment: Qty.: 0.3035 f(s)/Unit Total: 9.1035 f(s)
6061-T6 Bar 1.0" x 4.0"
batch: M11941

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blank 3.475" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA649 Rev: AA & Dwg D3502 Rev: A

15 dir: 11.078 hole

FF 06-10-17

60

2-Deburr per dwg D3502

mk/J.F. 06/10/12

60

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk/J.F. 06/10/12

60

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SL

06/10/14

60

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/14/17	6	DRILL 0.058 tooling hole for finishing as marked up on dwg.				UP 06/16/17 per 05/14/17	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/18/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:43:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 28476

Part Number: D35021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

yl 06/10/14 x 60

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 10 17 (60)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Stock Identify ST 448 PB 06/10/18 (60)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PB 06/10/18 (60) Stock Identify ST 448

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/18 (60)

Job Completion



u 20.10.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

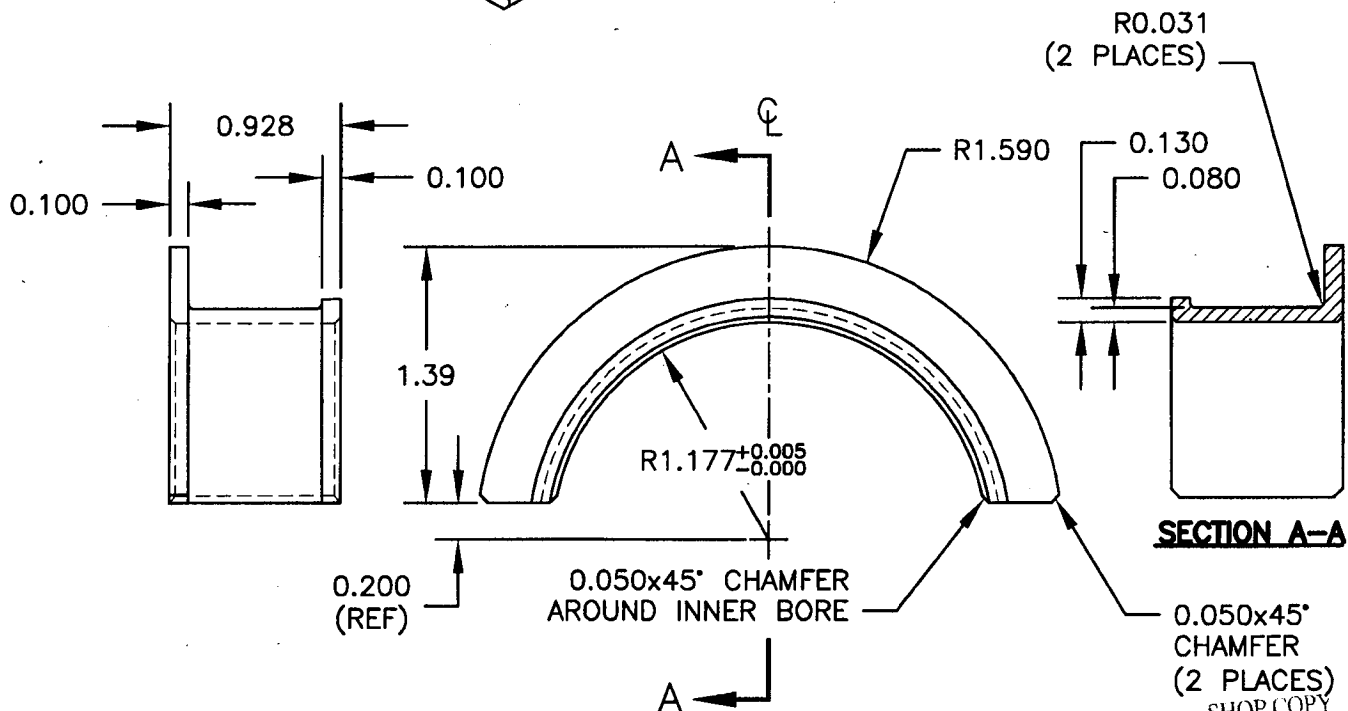
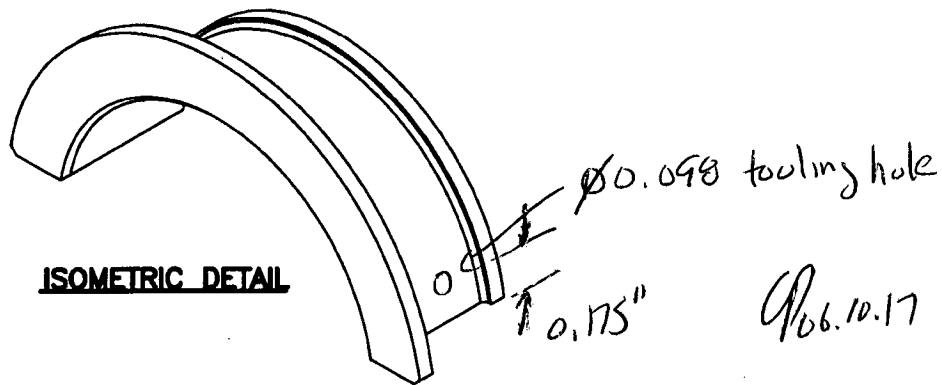
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN gp	DRAWN BY gp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3502	REV. A SHEET 1 OF 1
DATE 06.04.18		TITLE SUPPORT	SCALE 1:1
A	06.04.18	NEW ISSUE	



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28476
RELEASED

06.08.15 H

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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: September 25, 2006 11:45 AM
To: 'Chris Provencal'
Subject: RE: Deviation on D3502-1

This is acceptable.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Monday, September 25, 2006 8:59 AM
To: David Shepherd (David Shepherd)
Cc: 'S Shahbazian'
Subject: Deviation on D3502-1

David,

The D3502-1 Support for the 350 xtubes, there needs to be a 0.098 tooling hole to hand the part during finishing. I think you are already aware of this, we needed to do this to the preliminary parts. The drawing will be updated to add the optional tooling hole (when we update the xtube drawings for the finish), in the meantime we need permission for the hole.

Chris

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No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.405 / Virus Database: 268.12.6/453 - Release Date: 9/20/2006

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No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.405 / Virus Database: 268.12.6/453 - Release Date: 9/20/2006

17/10/2006